

Work Order ID 86729

July-06-12 11:46:07 AM

86729

Page 1

Item ID: D2199-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Details
 Start Date: 7/06/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2199	Rev E1								
100		0.00							
100	NC BRAKE								SB 12/07/17
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg D2199 and Spec Control Dwg D2638								
110		0.00							
110	Small Fab								Ae
Small Fab	Memo	0.00							12-07-18
Small Fab	Debur								12-08-01
120		0.00							
120	QC5- Inspect part completeness to step on W/O								Pro →
QC	Memo	0.00							
Quality Control									

SCRAP

W/O: 86729		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: P2198-23 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: for Date: 12/08/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AD Date: 12/08/14

NCR: 12-1654		WORK ORDER NON-CONFORMANCE (NCR) $39.02 \times 2 = 78.04$						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/01	#1 110	Found at inspection that the 0.316" hole was not drilled. when part was sent back to be drilled as	U 12/08/01	-Scrap + destr dth + 2 struts - cut off ends and mark original Material Batch #s	ke 12.08.01	DAS 16 2-03 12/08/01	U 12.08.01	DAS 16 2-03 12/08/01
		Per drawing set was returned to be drilled the hole was drilled over size measure 0.325" But employee didn't check		for use on other strut				DAS 16 2-03 12/08/01
		Drill bit before drilling hole. complete lack of attention in employees fault.						

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

MS 12/08/01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 86729

Parent Item: D2199-23

Parent Item Name: Strut Details

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D02.06.10Rem polish & add finishNG/CC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	686.9558	2.2	4.631579			

SS 12/07/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	686.955794	
109314	9.333	
111619	3	
112187	4	
112800	11	
114852	2.75	
116108	3	
117797	0.75	
120441	0.000794	
121170	234.89	
121666	18.232	
122312	400	

SS

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DART



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	98.03.22	ADD FINISH

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

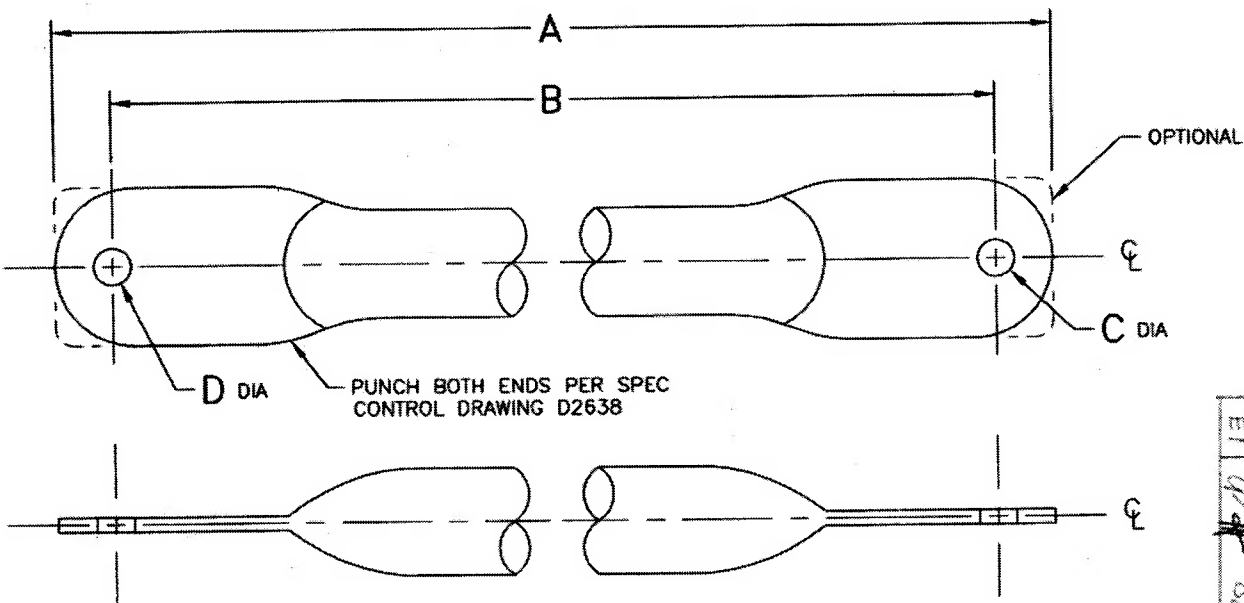
WORK ORDER

NO. 46229

110-075

BBBDDDDDD

#00.10.13
CP00.10.13



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 05 43/EN

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